



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE332A94-3400-03
Job Sheet 191110



Part No: RBE332A94-3400-03

Job Qty: 2 pcs

Part Name: Tail Rotor Drive Alignment Inspection



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/21/19

Job Tracking No:

Due Date: 3/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE332A94-3400-03 Rev A IPP Rev. A 19.02.19 New issue DP Verify DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S170158



Part: RBE332A94-3400-03

Job No: 191110

Serial No/Batch: S170158

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 04/06/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	Small Fab - 1	2 pcs	3/22/19		0.00	2.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
100	Small Fab - 2 - B4B	2 pcs	3/22/19		0.00	2.00	Small Fab - 1 - B4B		MLL
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
110	QC 5	2 pcs	3/22/19		0.00	0.00	QC 5 - 10		DAS APR 08 2019 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
120	Packaging 3-1 - Stock - B4B	2 pcs	3/22/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 21 APR 08 2019 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
130	QC 21 - FG	2 pcs	3/22/19		0.00	0.00	QC 21 - FG - 21		DAS 21 APR 08 2019
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op **100** - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 Descriptions: APP-2700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
 RBE332A94-3400-03-4 to RBE332A94-3400-03-3 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-IM2700-E GA	Case	2 Ea (1 ea)	95-Small Fab - 1	5163642
97524A032	Sealing Blind Rivet	8 Ea (4 ea)	100-Small Fab - 2 - B4B	5145165
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	100-Small Fab - 2 - B4B	5021040
RBE332A94-3400-03-12	Target Block 4 & 5	2 pcs (1 ea)	100-Small Fab - 2 - B4B	5162303
RBE332A94-3400-03-13	Target MGB / IGB / TGB	2 pcs (1 ea)	100-Small Fab - 2 - B4B	5169073
RBE332A94-3400-03-15	Target Block 2 to 6	2 pcs (1 ea)	100-Small Fab - 2 - B4B	5162378
RBE332A94-3400-03-16	Target Block 1 Fabrication	2 pcs (1 ea)	100-Small Fab - 2 - B4B	5170130
RBE332A94-3400-03-19	Target Block 1 Fabrication	2 pcs (1 ea)	100-Small Fab - 2 - B4B	5170143
RBE332A94-3400-03-2	Bottom Foam use in case APP-IM2700-E	2 Ea (1 ea)	100-Small Fab - 2 - B4B	5163640
RBE332A94-3400-03-21	Target Block 1 User	2 pcs (1 ea)	100-Small Fab - 2 - B4B	5170136
RBE332A94-3400-03-24	Target Block 1 User	2 pcs (1 ea)	100-Small Fab - 2 - B4B	5170148
RBE332A94-3400-03-3	Top Foam use in case APP-IM2700-E	2 Ea (1 ea)	100-Small Fab - 2 - B4B	5163647
RBE332A94-3400-03-4	Location Placard	2 pcs (1 ea)	100-Small Fab - 2 - B4B	5161360
RBE332A94-3400-03-5	Sight Support	2 pcs (1 ea)	100-Small Fab - 2 - B4B	5168026
RBE332A94-3400-03-9	Sight Support	2 pcs (1 ea)	100-Small Fab - 2 - B4B	5170155

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
95-Small Fab - 1	APP-IM2700-E	2	5	0
100-Small Fab - 2 - B4B	97524A032	8	409	0
	RB41011	2	371	0
	RBE332A94-3400-03-12	2	5	0
	RBE332A94-3400-03-13	2	0	0
	RBE332A94-3400-03-15	2	5	0
	RBE332A94-3400-03-16	2	0	0
	RBE332A94-3400-03-19	2	0	0
	RBE332A94-3400-03-2	2	2	0
	RBE332A94-3400-03-21	2	0	0
	RBE332A94-3400-03-24	2	0	0
	RBE332A94-3400-03-3	2	2	0
	RBE332A94-3400-03-4	2	3	0
	RBE332A94-3400-03-5	2	0	0
	RBE332A94-3400-03-9	2	0	0

Part Specifications

Specifications could not be found.

Plex 3/22/19 11:51 AM Dart.Hadley.Shannon

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RBE332A94-3400-03
Job Sheet 191110



Part No: RBE332A94-3400-03

Job Qty: 2 pcs

Part Name: Tail Rotor Drive Alignment Inspection



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/21/19

Job Tracking No:

Due Date: 3/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 11803*

Note: DWG RBE332A94-3400-03 Rev A IPP Rev. A 19.02.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	3/22/19		0.00	2.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	3/22/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
120	Packaging 3-1 - Stock - B4B	2 pcs	3/22/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
130	QC 21 - FG	2 pcs	3/22/19		0.00	0.00	QC 21 - FG - 21		
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 Descriptions: APP-2700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
 RBE332A94-3400-03-4 to RBE332A94-3400-03-3 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

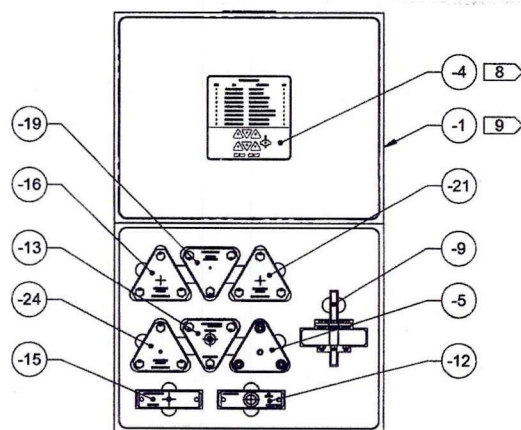
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	8 Ea (4 ea)	100-Small Fab - 1	
APP-IM2700-E	Case	2 Ea (1 ea)	100-Small Fab - 1	
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	100-Small Fab - 1	
RBE332A94-3400-03-1	Packaging Assembly	2 (1 ea)	100-Small Fab - 1	
RBE332A94-3400-03-12	Target Block 4 & 5	2 pcs (1 ea)	100-Small Fab - 1	
RBE332A94-3400-03-13	Target MGB / IGB / TGB	2 pcs (1 ea)	100-Small Fab - 1	
RBE332A94-3400-03-15	Target Block 2 to 6	2 pcs (1 ea)	100-Small Fab - 1	
RBE332A94-3400-03-16	Target Block 1 Fabrication	2 pcs (1 ea)	100-Small Fab - 1	
RBE332A94-3400-03-19	Target Block 1 Fabrication	2 pcs (1 ea)	100-Small Fab - 1	
RBE332A94-3400-03-2	Bottom Foam	2 (1 ea)	100-Small Fab - 1	
RBE332A94-3400-03-21	Target Block 1 User	2 pcs (1 ea)	100-Small Fab - 1	
RBE332A94-3400-03-24	Target Block 1 User	2 pcs (1 ea)	100-Small Fab - 1	
RBE332A94-3400-03-3	Top Foam	2 (1 ea)	100-Small Fab - 1	
RBE332A94-3400-03-4	Location Placard	2 pcs (1 ea)	100-Small Fab - 1	
RBE332A94-3400-03-5	Sight Support	2 pcs (1 ea)	100-Small Fab - 1	
RBE332A94-3400-03-9	Sight Support	2 pcs (1 ea)	100-Small Fab - 1	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	97524A032	8	446	0
	APP-IM2700-E	2	4	0
	RB41011	2	409	0
	RBE332A94-3400-03-1	2	0	0
	RBE332A94-3400-03-12	2	0	0
	RBE332A94-3400-03-13	2	0	0
	RBE332A94-3400-03-15	2	0	0
	RBE332A94-3400-03-16	2	0	0
	RBE332A94-3400-03-19	2	0	0
	RBE332A94-3400-03-2	2	0	0
	RBE332A94-3400-03-21	2	0	0
	RBE332A94-3400-03-24	2	0	0
	RBE332A94-3400-03-3	2	0	0
	RBE332A94-3400-03-4	2	0	0
	RBE332A94-3400-03-5	2	0	0
	RBE332A94-3400-03-9	2	0	0
Part Specifications				
Specifications could not be found.				

Plex 2/21/19 12:50 PM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-1	1	RBE332A94-3400-03-1	PACKAGING ASSEMBLY
-4	1	RBE332A94-3400-03-4	LOCATION PLACARD
-5	1	RBE332A94-3400-03-5	SIGHT SUPPORT
-9	1	RBE332A94-3400-03-9	SIGHT SUPPORT
-12	1	RBE332A94-3400-03-12	TARGET BLOCK 4 & 5
-13	1	RBE332A94-3400-03-13	TARGET MGB / IGB / TGB
-15	1	RBE332A94-3400-03-15	TARGET BLOCK 2 TO 6
-16	1	RBE332A94-3400-03-16	TARGET BLOCK 1 FABRICATION
-19	1	RBE332A94-3400-03-19	TARGET BLOCK 1 FABRICATION
-21	1	RBE332A94-3400-03-21	TARGET BLOCK 1 USER
-24	1	RBE332A94-3400-03-24	TARGET BLOCK 1 USER
26	1	RB41011	DART PLACARD
27	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.

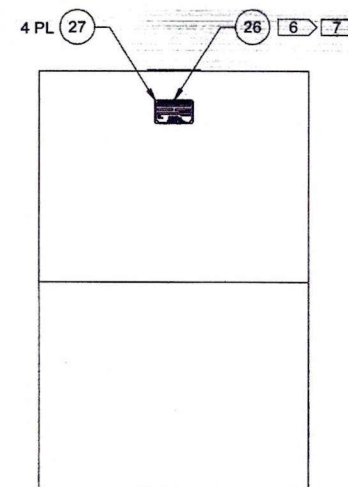
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191110 MLS
19-02-21



RBE332A94-3400-03 T/R DRIVE ALIGNMENT INSPECTION

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
- 7) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
- 8) HOT GLUE THE LOCATION PLACARD ONTO THE TOP FOAM
- 9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE



A	NEW ISSUE	19-585	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT	REV. A	
CHECKED	MBB	TOOL PART #	SHEET 1 OF 26
MFG. APPR.	DP	RBE332A94-3400-03	
APPROVED	VJP	TITLE	SCALE
		T/R DRIVE ALIGNMENT INSPECTION	NTS
DATE 2/14/2019		COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					